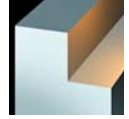


# 7200 VM 06\_R Half Side Disc Cutters

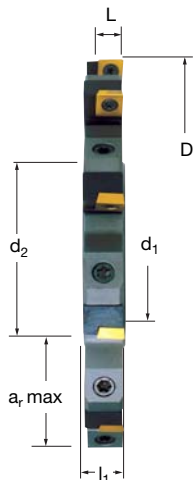


## 7200 VM 06\_R Assembled Disc & Cartridge

EDP #	Assembled Part Number	Dimensions (inch)						No. of Inserts	Spares		EDP#	EDP#	EDP#	EDP#
		D	L	I <sub>1</sub>	d <sub>1</sub>	d <sub>2</sub>	a <sub>r</sub> max.		EDP#	Cartridge				
016740	A7200VM06-100R08/09	3.94	0.248	0.472	1.25	1.89	0.90	12	016761	72VMR08/09	015060	F2505T	018488	T7
016741	A7200VM06-100R09/10	3.94	0.248	0.472	1.25	1.89	0.90	12	016762	72VMR09/10	015060	F2505T	018488	T7

## 7200 VM 06\_R Cartridge Spares

EDP #	Cartridge Part Number	Cartridge			
		EDP#	EDP#	EDP#	EDP#
016761	72VMR08/09	015258	72.697T	015240	T15
016762	72VMR09/10	015258	72.697T	015240	T15

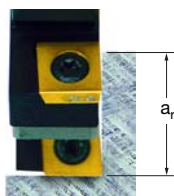


## 7200 VM 06\_R Technical Advice

Milling Cutter Order Example: **A7200VM06-100R08/09**  
 Milling Insert Order Example: **MPHW0602PPTR X500**  
 For complete cutting conditions refer to page: **208**



Disc Cutter & Cartridge



Depth of Cut (a<sub>r</sub>)

### IMPORTANT

For a given  $f_z$  (in./tooth) feed rate, **the thickness of the chip  $h_m$**  (effective feed rate per tooth) **decreases with the depth of cut  $a_r$** . It is imperative that this parameter be taken into account when selecting the machine feed rate, calculated in accordance with the formula below:

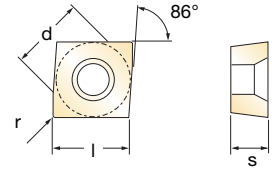
### FORMULA EXAMPLE

$$h_m = \sqrt{\frac{a_r}{D}} \times f_z$$

$$h_m = \sqrt{\frac{0.4}{6.3}} \times 0.004 = 0.001$$

$a_r$  = Depth of Cut (D.O.C.)     $f_z$  = Feed per tooth  
 $D$  = Cutter diameter             $h_m$  = Effective chip thickness

# Inserts for 7200 VM 06\_R



EDP#	Part Number	Grade	Application & Material			Dimensions (inch)				
			Roughing ▼	Semi-Finishing ▼▼	Finishing ▼▼▼	d	l	s	r	h <sub>m</sub> min
024927	<b>MPEX0602PPFR-701</b>	<b>GH1</b>	◆	◆	◆	0.250	0.250	0.094	Facet	0.0008
017638	<b>MPEX0602PPFR-701</b>	<b>SFZ</b>				0.250	0.250	0.094	Facet	0.0008
017649	<b>MPFW0602PPTR</b>	<b>GH1</b>				0.250	0.250	0.094	Facet	0.0028
017647	<b>MPFW0602PPTR</b>	<b>SF30</b>				0.250	0.250	0.094	Facet	0.0028
014400	<b>MPFW0602PPTR</b>	<b>SFZ</b>	◆◆	◆◆	◆◆	0.250	0.250	0.094	Facet	0.0028
017648	<b>MPFW0602PPTR</b>	<b>X44</b>				0.250	0.250	0.094	Facet	0.0028
023247	<b>MPHT0602PPER</b>	<b>X44</b>				0.250	0.250	0.094	Facet	0.0016
017301	<b>MPHW0602PPTR</b>	<b>MP91M</b>	◆	◆	◆	0.250	0.250	0.094	Facet	0.0028
023253	<b>MPHW0602PPTR</b>	<b>PFZ</b>				0.250	0.250	0.094	Facet	0.0028
017668	<b>MPHW0602PPTR</b>	<b>X500</b>	◆	◆	◆	0.250	0.250	0.094	Facet	0.0028



## Recommended Cutting Conditions

Material	Speed V <sub>C</sub> (feet/min)	Feed h <sub>m</sub> (inch)
◆ Unalloyed Steels	600 - 720	0.003 - 0.005
◆ Alloyed Steels	230 - 360	0.003 - 0.004
◆ Stainless Steels	400 - 450	0.003 - 0.005
◆ PH Stainless	-	-
◆ Cast Irons	460 - 910	0.003 - 0.004
◆ Aluminum & Alloys	910 - 1470	0.002 - 0.005
◆ High Temp. Alloys	-	-
◆ Hard Steels (52-56 HRC)	-	-

h<sub>m</sub> = average chip thickness

## Star Guide Key to Recommended Tools

Material Designations								
	◆ P	Unalloyed Steels	◆ M	Stainless Steels	◆ K	Cast Irons	◆ S	High Temp. Alloys
	◆ P	Alloyed Steels	◆ M	PH Stainless	◆ N	Aluminum & Alloys	◆ H	Hard Materials